

# Work Order ID 80088

\*80088\*

Page 1

February-09-12 4:28:57 PM

Item ID: D4527-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket

Start Date: 09/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: ALJ

Date: 12/02/10

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4527

A

110

0.00

\*110\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS DWG

DWG REV: A

PROG REV: A

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

W 12, 02, 16 (10)

W 12, 02, 16 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80088

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**\*80088\***

Page 2

Item ID: D4527-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 09/02/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

0.00

**\*140\***

Small Fab

Memo

0.00

Small Fab

1- Drill holes as per dwg

2- C'sink hole as per dwg

3- Ream 1.000" hole as per dwg

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**\*80088\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:**

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Tooling:**

Date:

Stop \*NR2\*

SPC (Y/N):

Date:

**Insp.  
Stamp**

0.00

**\*160\***

HandFinish

## Memo

0.00

## Hand Finishing

0.00

**\*170\***

QC

## Memo

0.00

## Quality Control

Identify as per dwg & Stock Location: 195

0.00

**\*180\***

### Packaging

## Memo

0.00

### Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 80088****\*80088\***

Page 4

February-09-12 4:28:57 PM

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Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 09/02/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MLJ 12/03/09

MF  
12-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

February-09-12 4:29:00 PM

Page 1

Work Order ID: 80088

\*80088\*

Parent Item: D4527-1

\*D4527-1\*

Parent Item Name: Bracket

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.29 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X08.00 0		Purchased	No			110	f	20.7000	0.59	6,210,526			

\*M6061T6B0 750X08 000\*

6061-T6 BAR .750" X 8.00"

\*\*

12-02-16

Location

Loc Qty

Loc Code

MAT003

20.7

119231

20.7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



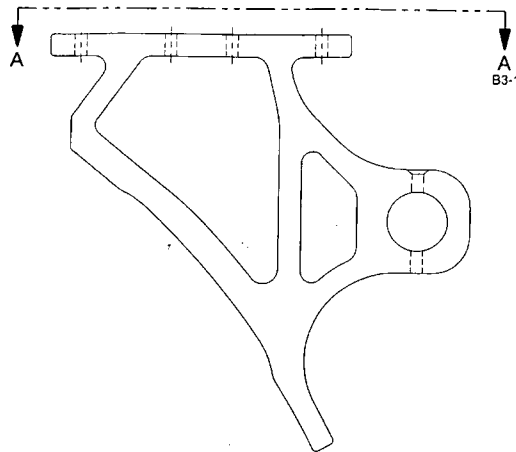
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

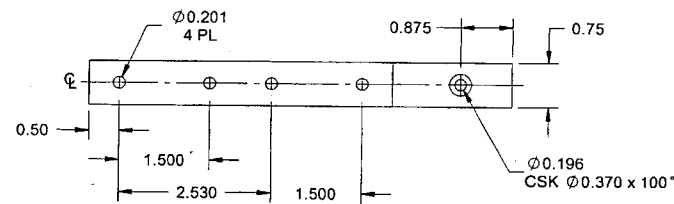
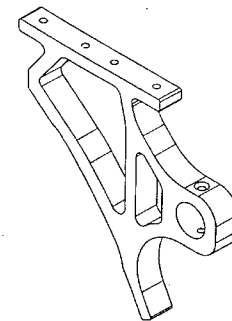
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPY  
 INTO  
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 CE  
 FR  
 80088 M.C.J  
 12/02/10







SECTION VIEW A-A D6-1

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR ASTM B211 OR ASTM B221  
 OR 6061-T6/T62 ALUMINUM SHEET  
 PER QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lbs

D4527-1 BRACKET

RELEASED  
 2011-11-28  
 JWP

A		NEW ISSUE		RF	11.11.22
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA			
DRAWN	RF				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4527	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		BRACKET	NTS		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

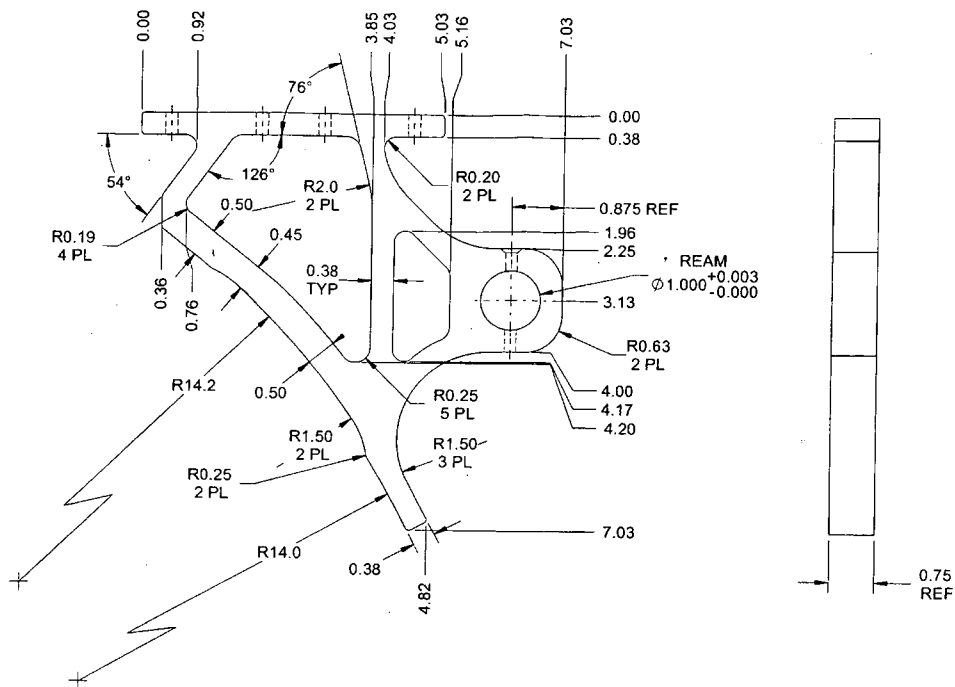
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

90088



**D4527-1 BRACKET**

RELEASE  
R 2011-11-28  
MP

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

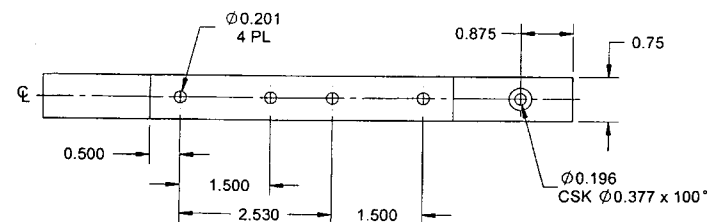
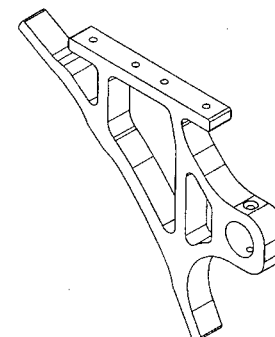
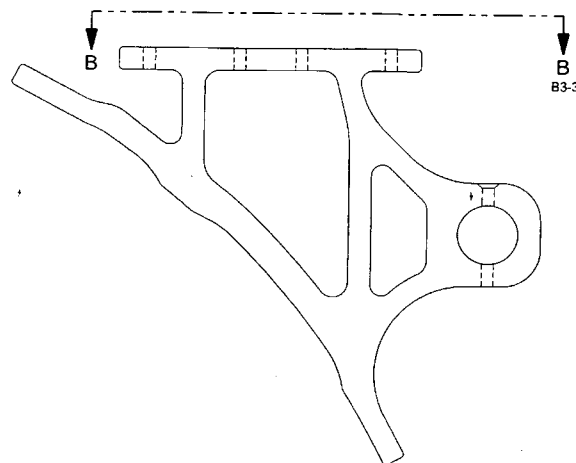
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80088



SECTION VIEW B-B B5-3

**D4527-3 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.90 lbs

**RELEASED**  
R 2011-11-28  
JP

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4527</b>	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
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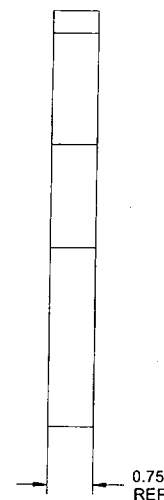
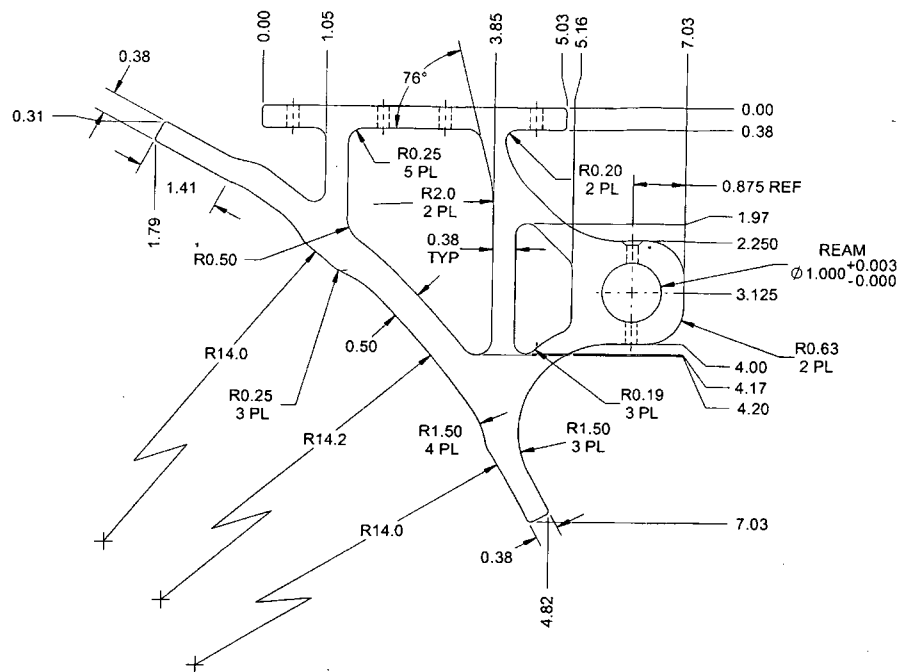
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**D4527-3 BRACKET**

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2011-11-28

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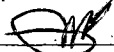
**NOTE:** Date & initial all entries

# FIRST ARTICLE INSPECTION CHECKLIST

PART AEROSPACE LTD		Work Order: 80088
Description: BRACKET		Part Number: 4527-1
Inspection Dwg: 4527		Rev: A
Page 1 of 1		

☒ First Article
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
150		$\pm .030$	1504	—		RA26	Yes
1.500		$\pm .010$	1.503	—		"	
2.530		$\pm .010$	2.532	—		"	
1.500		$\pm .010$	1.502	—		"	
1.875		$\pm .010$	1.877	—		"	
$\phi .201$		$\pm .005$	$\phi .203$	—		RA26	
$\phi .196$		$\pm .004$	$\phi .196$	—		"	
$\phi 1.000$		$\pm .003$	1.001	—		RA26	Yes

Measured by: 	Date: 12/02/17	Audited by: S	Date: 12/02/17	Prototype Approval: _____	Date: _____
Rev	Date	Change	Revised by	Approved	KJULM